

SPLIT

ork Order ID 78684 -1

78684

Page 1

January-12-12 10:56:00 AM

Item ID: D2841-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly, 206 Float
 Start Date: 12/01/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/12 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2841	Rev B								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2841-1 using D2622 extrusion as per Dwg D2841								
	2-Drill extrusion per drawing D2841 using Jig DT 8265								
	3-Deburr and bevel ends for welding								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

12.02.24 4/6
 12-02-17

12.02.24 (4)

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January-12-12 10:56:00 AM

Item ID: D2841-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Assembly, 206 Float
 Start Date: 12/01/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Large Fab Large Fab	Large Fab Memo 1-Weld end cap(AFT END ONLY) 2-weld lugs as per Dwg D2841 using Jig DT 8267 followed by DT 8268 A/R AL ROD Batch: 119785 3-Grind end cap welds flush 120169	0.00 0.00				4	0		
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BE 12/02/27	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			47

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Item ID: D2841-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly, 206 Float

Start Date: 12/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12.02.29 4 0

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12/02/29 (4)

170

Large Fab

0.00

170

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024
2-Weld Remainig end cap as per Dwg D2841
A/R AL ROD Batch: 119185
3- grind end cap welds flush as per dwg D2841

12.03.05 4 0

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January-12-12 10:56:00 AM

Item ID: D2841-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, 206 Float
 Start Date: 12/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8h10 OVEN TEMPERATURE: 320°F FINISH TIME: 8h40 M120222	0.00 0.00				4	(OP) BL 12/03/06		
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	4	12/02/06	
220 *220* HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: _____	0.00 0.00							Pho →

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January-12-12 10:56:00 AM

Item ID: D2841-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Assembly, 206 Float

Start Date: 12/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

240

Identify as per dwg & Stock Location:

0.00

240

Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00

250

QC

Memo

0.00

Quality Control

⑦
44

012/3/7 (2)

MLJ 12/03/07

MF
12-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January-12-12 10:56:04 AM

Work Order ID: 78684

78684

Parent Item: D2841-041

D2841-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	*NAS1149C0332 R	✓ Purchased	No	120648.		100	Each	0.0000	4	16			

*AN960C10I *

washer

D2622-120C

Manufactured

No

120

Each

54.4700

1

4

D2622-120C

Step Extrusion

**

16.

**

B77612 (x4) Ae 12/02/13

Location

Loc Qty

Loc Code

HALL

16.47

46910

2

64409

6

66970

7.7

68293

0.35

72131

0.42

WA013

38

75781

38

D2734

Manufactured

No

120

Each

132.0000

2

8

D2734

Step End Plate

**

12.02.24

Location

Loc Qty

Loc Code

WA

132

76985

132

8

Picklist Print

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Work Order ID: 78684

78684

Parent Item: D2841-041

D2841-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3464-1

Manufactured No

120 Each 26.0000 1 4

D3464-1

Float Step Mounting Plate

**

12.02.25

Location

Loc Qty

Loc Code

WA003

26

37348

8

44607

18

D3464-3

Manufactured No

120 Each 21.0000 1 4

D3464-3

Float Step Mounting Plate

**

12.02.25

Location

Loc Qty

Loc Code

WA017

21

37349

6

37791

15

D3464-5

Manufactured No

120 Each 35.0000 1 4

D3464-5

Float Step Mounting Plate

**

12.02.25

Location

Loc Qty

Loc Code

WA003

35

54069

35

D3464-7

Manufactured No

220 Each 19.0000 1 4

D3464-7

Float Step Mounting Plate

**

12.02.25

Location

Loc Qty

Loc Code

WA004

19

44608

19

Picklist Print

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Work Order ID: 78684

Parent Item: D2841-041

Parent Item Name: Step Assembly, 206 Float

78684

D2841-041

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS27039C1-07

Purchased

No

220

Each

33.0000

4

16

**

MS27039C1-07
screw

Location

Loc Qty

Loc Code

ST293

33

117423

8

118686✓

25

220

Each

82.0000

4

16

**

NAS1329C3KB130

Purchased

No

NAS1329C3KB130
insert

Location

Loc Qty

Loc Code

ST276

82

117679✓

7

118984✓

75

220

Each

171.0000

4

16

**

NAS1515H3L

Purchased

No

*NAS1515H3I *
WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

131

118686

3

119438 /

28

120072 /

100

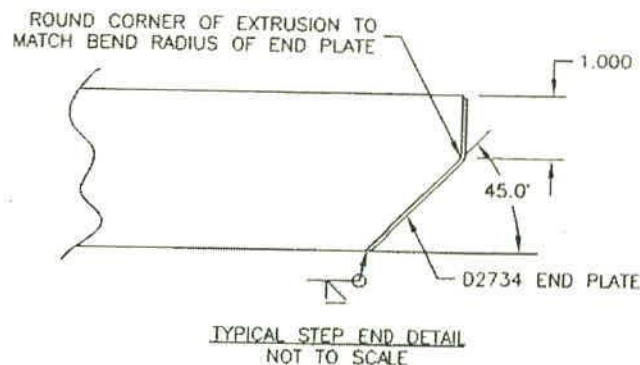
16

January-12-12 10:56:04 AM

Shop Packet Print

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DESIGN KE	DRAWN BY JH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D2841	REV. B SHEET 1 OF 1
DATE 05.09.21	TITLE 206B FLOAT STEP ASSEMBLY SCALE NTS		
A	98.10.14	NEW ISSUE	
B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7	



QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2841-041	LH STEP ASSEMBLY
	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3K8130 (OR A65510K8130)	INSERT
4	4	M527039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

D2841-041/-042 STEP ASSEMBLY

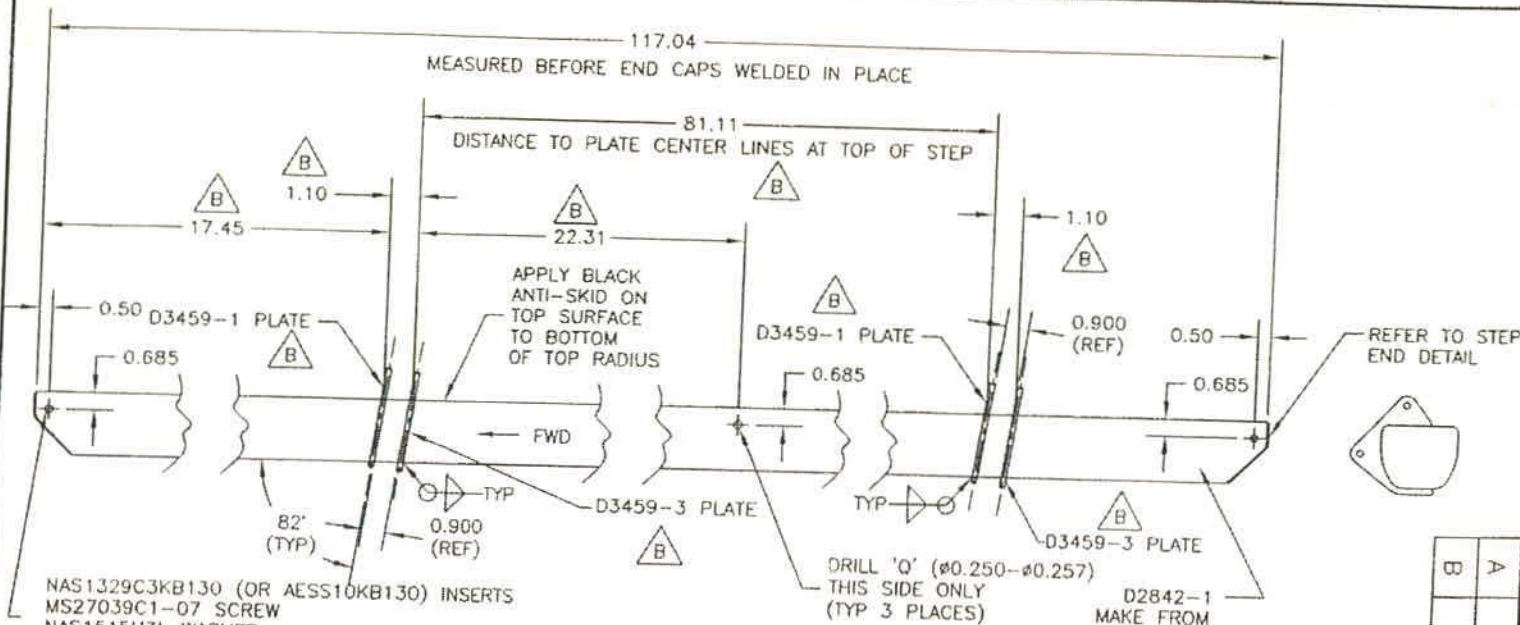
- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

78084
M.L.J
12/01/12

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DART



NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

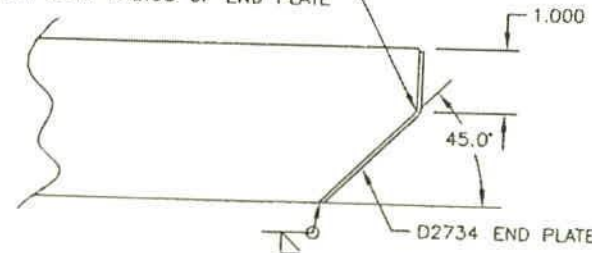
D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	DRAWING NO.	D2842	REV. B
		TITLE	206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
	A		98.10.13	SCALE
	B		05.09.23	NTS
			RE-DESIGN, ADD D3459-1/-3	

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